

Work Order ID 105597

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August-08-13 1:22:32 PM

Item ID: D2696-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Leg
 Start Date: 8/08/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/08/13 Req'd Qty: 1.00 *1* Customer:
 Reference: RE-POWDERCOAT *Rework*

Approvals: Process Plan: *u* Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2696	Rev C								

140 Chemical Conversion Coat per QSI005 4.1 0.00

140

HandFinish

Hand Finishing

Memo

PULL FROM STK:
1 X D2696-1 B15058
STRIP COMPLETELY
RE-ALODINE

0.00

150 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00

150

Powdercoat

Powder Coating

Memo

REPOWDERCOAT WHITE PER QSI005
START TIME: 8:30 OVEN TEMPERATURE:
FINISH TIME: 9:00

0.00

160 QC-3- Inspect Part Finish 0.00

160

QC

Quality Control

Memo

0.00

DAY
05 13/08/13

1X M-1 13/08/14

1X d 13/08/14

m126125

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Item ID: D2696-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lcg
 Start Date: 8/08/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/08/13 Req'd Qty: 1.00 *1* Customer:
 Reference: RE-POWDERCOAT

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>8D230</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging	RE-IDENTIFY USING NEW B/N								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

IX
 13-8-15
 13/8/20
 MLS 13-08-15

Picklist Print

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Parent Item: D2696-1

Start Date: 8/08/13

Required Date: 8/08/13

Parent Item Name: Leg

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C00.11.01Removed P/O for Powder Coat - in house processEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2696-1 Leg		Manufactured	No				Each	1.0000		1			<i>h</i>

Location

Loc Qty

Loc Code

Mezz

1

15058

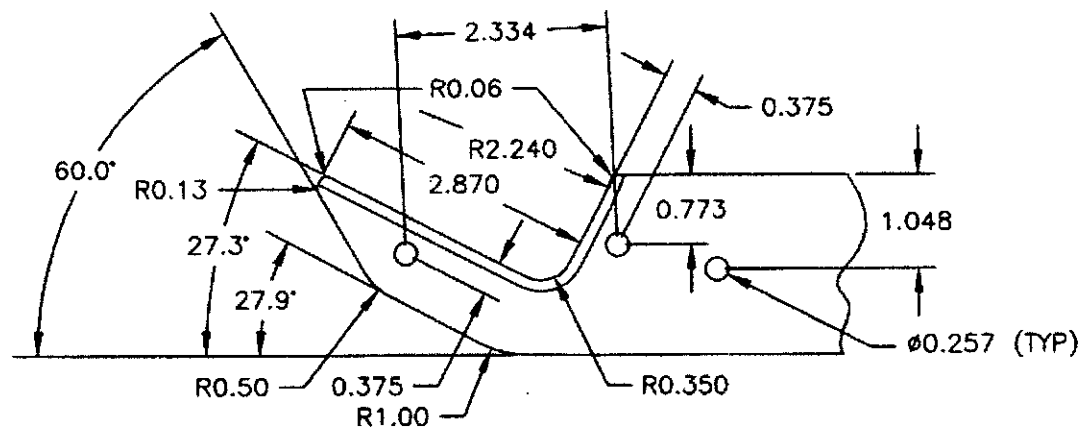
1

1

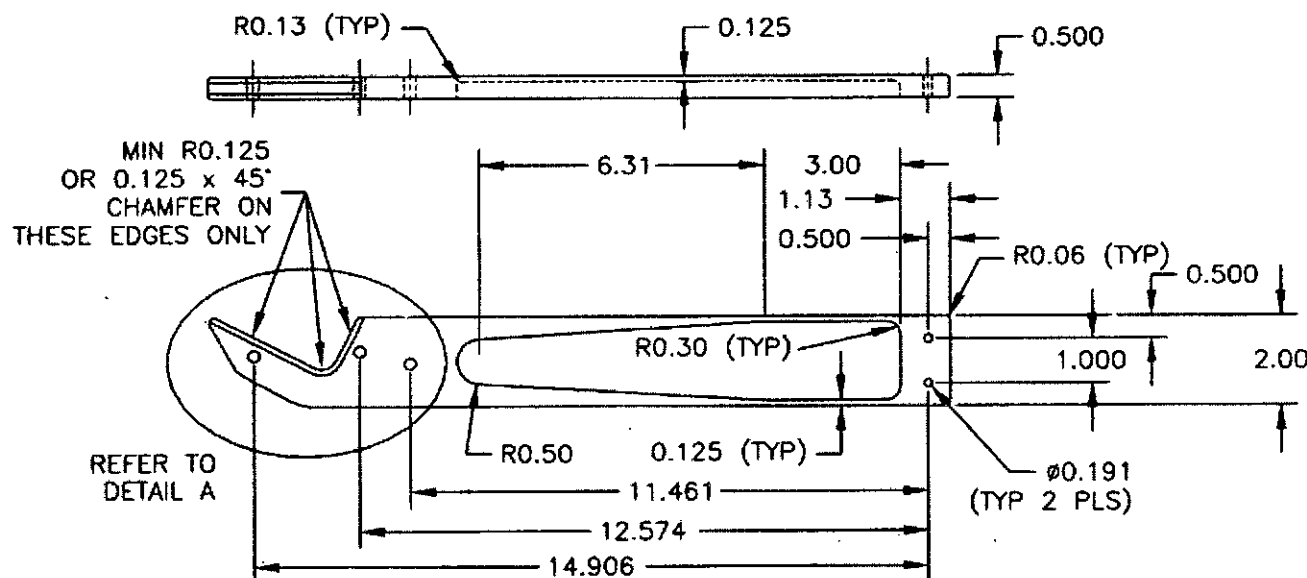
DART**RELEASED**
K/E 99.11.19

DESIGN	CHECKED	APPROVED	DATE	TITLE	SCALE
4E	4E		99.11.03	STA 129 LEG	1:4
A			97.09.10	NEW ISSUE	
B			99.10.20	UPDATE TOLERANCE, DELETE ENGRAVING	
C			99.11.03	CHANGED GEOMETRY IN DETAIL A ADDED FINISH	

DESIGNED BY	DART AEROSPACE LTD
CHECKED BY	HAWKESBURY, ONTARIO, CANADA
APPROVED BY	
DRAWING NO.	D2696
SHEET 1 OF 1	
REV. C	

**DETAIL A**

SCALE: 1:2



D2696-1 LEFT HAND (SHOWN)
D2696-2 RIGHT HAND (OPPOSITE)

NOTE: DEBURR ALL EDGES R0.03 - R0.06**MATERIAL: 6061-T6 OR 6061-T651 (QQ-A-225/8 OR QQ-A-200/8 OR QQ-A-250/11)****TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED****FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1****POWDER COAT PER DART QSI 005 4.3 WHITE (4.3.5.1) OR
GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7)**

